



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3557-1

Job Sheet 201015



Part No: D3557-1

Job Qty: 5 pcs

Part Name: Bracket

Status: New

Priority: Medium

Job Tracking No:

Created By: Mario Lajeunesse

Description:

Issue 06-09-18 JLM

Scrap

Bill of Materials

Job Routing

Due Date	Standard		Workcenter/Supplier		Sign-off
	Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
9/27/19	0.17	0.13	Waterjet - Flow	9/25/19	JRB
9/27/19	0.00	0.00	QC 2 - 1		
			QC 2 - 12		
			QC 2 - 14		
			QC 2 - 17		
			QC 2 - 19		
			QC 2 - 2		
			QC 2 - 20		
			QC 2 - 22		
			QC 2 - 23		
			QC 2 - 25		
			QC 2 - 32		
			QC 2 - 33		
			QC 2 - 35		
			QC 2 - 39		
			QC 2 - 4		
			QC 2 - 40		
			QC 2 - 44		
			QC 2 - 45		
			QC 2 - 48		
			QC 2 - 49		
			QC 2 - 50		
			QC 2 - 51		
			QC 2 - 52		
			QC 2 - 57		
			QC 2 - 62		
			QC 2 - 63		
			QC 2 - 8		
			QC 2 - 66		
			QC 2 - 64		

110 QC 2

5 pcs

Date: 09/26/19

PRIORITY

Instructions: Various STC's

Part: D3557-1
Job No: 201015
Serial No/Batch: S216943

Revision:
Inspector:
Exp Date:

Container No: S216943

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120 QC 8	5 pcs	9/27/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	9/25/19 JLB
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	SEP 26 2019 DAS 40 9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	5 pcs	9/27/19	0.25 0.12	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	5 pcs	9/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	5 pcs	9/27/19	0.00 0.07	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	

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				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White GI(A)- B4B	5 pcs	9/27/19	0.00 0.14	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	5 pcs	9/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
180 Packaging 3-1 - Stock - B4B	5 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	5 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg D3557 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> ****Ensure Grain Direction is Correct**** 2- Descriptions: Deburr if necessary 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - (Bend/Assemble as per dwg), Bend as per Dwg D3557 140 - QC5- Inspect part completeness to step on W/O 150 - Chemical Conversion Coat per QSI005 4.1 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 170 - QC3- Inspect Part Finish 180 - Identify as per dwg & Stock Location: _____ 190 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.125	6061-T6 .125 Sheet	.1750 sf (.035 ea)	100-Waterjet - Flow - 1	S167957	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M6061T6S.125	0	17	0	
Part Specifications					
Specifications could not be found.					

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

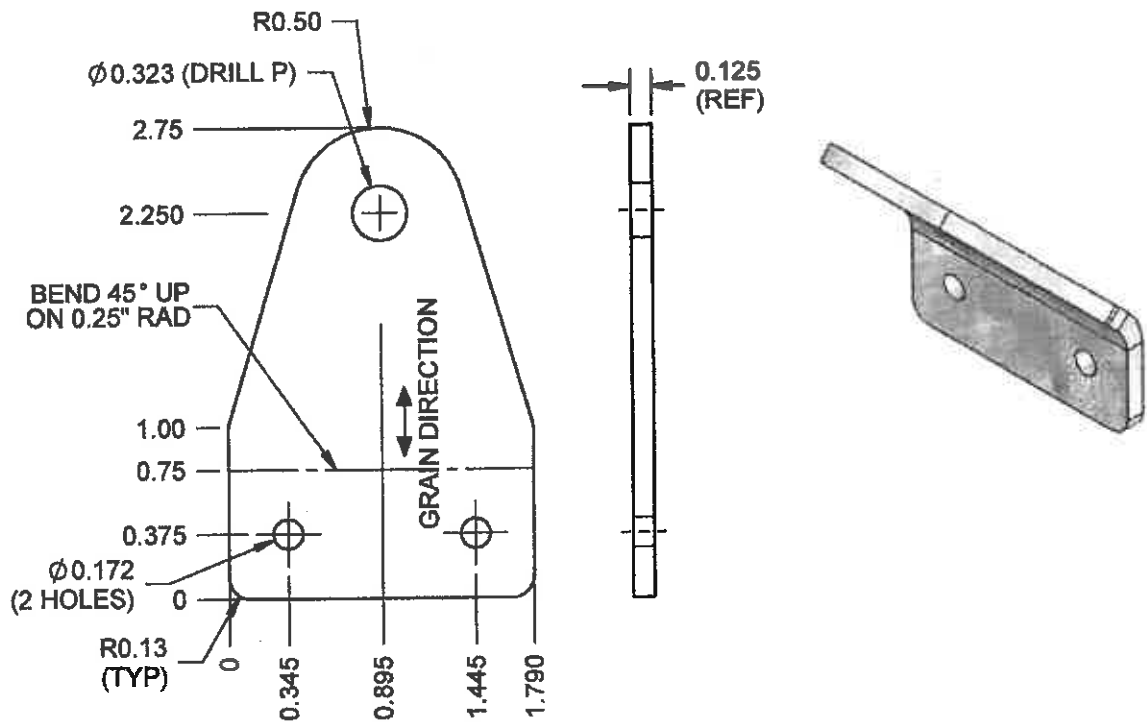
NCR No. _____

Route update only ☐

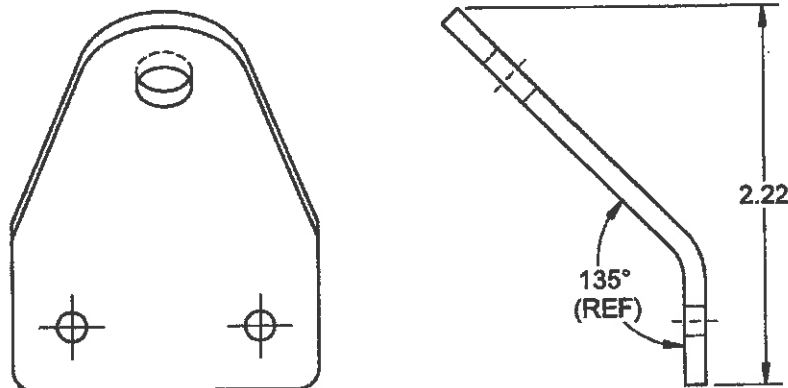
Job: <u>201015</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>D35574</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>SEP 26 2019</u>	Sequence #: <u>120</u>	QTY Affected: <u>10 of 10</u>		MRS (QSI042) <u>68</u>		SEP 26 2019					
Description Work Order Deviation				Disposition							
<u>wrong grain direction</u>				<u>-Scrap</u>							
Root Cause		FAULT CATEGORY									
☒ Operator		☐ Pressure/Forced		☐ Contamination		☐ Power Loss/Surge		☐ Positioned Wrong		☐ Outside Tolerance	
☐ Manufacturing Process		☐ Bending		☐ Misaligned/off center		☐ Folio/Program		☐ Drawing		☐ Finish	
☐ Equip/Tooling		☐ Crushing		☐ BOM/Route		☒ Grain Direction		☐ Weld		☐ Part Lost/Missing	
☐ Handling/Preservation		☐ Cracks		☐ Broken/Damage/Defect		☐ Wrong Stock Pulled		☐ Out of Sequence		☐ Misread	
☐ Material		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Drill Holes		☐ Off-set/Set-up			
☐ Product Improvement		☐ Marks/Chatter		☐ Fit/Function							
☐ Process Improvement		☐ Mislabeled									
☐ Human Factors											
		Other/Details:									
Completed By <u>DAS</u> <u>40</u> SEP 26 2019 9:39 Lead hand / Supervisor											
QC / QA Coordinator <u>68</u> <u>9 39</u> SEP 26 2019											



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3557	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE BRACKET	SCALE 1:1	
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	



D3557-1F FLAT PATTERN



D3557-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3557-1 USING FINE POINT PERMANENT MARKER

RELEASED
06.10.13

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